

Work Order ID 65152

Thursday, January 06, 2011 2:55:59 PM



Page 1

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt

Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 1/01-6

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

0.00



Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871 AND DWG

Prog Rev:

Dwg Rev:

B

[Signature]

11/1/17

Deburr as required

6 *[Signature]*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

[Signature]

11/1/17

6 *[Signature]*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/01/18

6

Quality Control

130

Identify as per dwg & Stock Location: 91

0.00



Packaging

Memo

0.00

11/1/18

6

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/01/19

Quality Control

MF
11-01-18

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 2:56:08 PM

Page 1

Work Order ID: 65152



Parent Item: D3912-1



Parent Item Name: Eyebolt


Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R2.000  303 ROUND BAR 2" | | Purchased | No | | | 100 | f | 0.0000 | 0.25 | 1.578947 | | 11/11/18 | |

304 2"

M 115385

1.6 RT

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


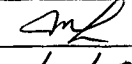
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

NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 65152 |
| Description: Eyebolt | | Part Number: D3912-1 |
| Inspection Dwg: D3912 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 0.13 | +/-0.030 | .132 | / | | Vern | |
| Ø0.700 | +/-0.010 | Ø.701 | / | | | |
| Ø0.500 | +/-0.010 | Ø.501 | / | | | |
| 0.90 | +/-0.030 | .898 | / | | | |
| 0.13 x 45° | +/-0.030 x 0.5° | .140 x 45° | / | | | |
| 0.22 | +/-0.030 | .225 | / | | | |
| 0.75 | +/-0.030 | .751 | / | | | |
| 0.970 | +/-0.010 | .971 | / | | | |
| 1.72 | +/-0.030 | 1.715 | / | | | |
| 1.20 | +/-0.030 | 1.198 | / | | | |
| 0.625 | +/-0.010 | .625 | / | | | |
| 2.23 | +/-0.030 | 2.228 | / | | | |
| R0.13 | +/-0.030 | R.13 | / | | | |
| R0.015 | +/-0.010 | R.015 | / | | Rad-gage | |
| 0.625 | +/-0.010 | .625 | / | | | |
| Ø0.650 | +/-0.010 | Ø.649 | / | | | |
| 1.100 | +/-0.010 | 1.101 | / | | | |
| 0.44 | +/-0.030 | .440 | / | | | |
| R0.13 | +/-0.030 | R.13 | / | | Rad-gage | |
| 1.00 | +/-0.030 | 1.01 | / | | | |
| 0.25 | +/-0.030 | .248 | / | | | |
| 0.88 | +/-0.030 | .881 | / | | | |
| 0.11 | +/-0.030 | .112 | / | | | |
| Ø0.719 | +0.010/-0.000 | Ø.723 | / | | | |
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|---|--|------------------------------|
| Measured by:  | Audited by:  | Preliminary Approval: |
| Date: 11/11/17 | Date: 11/01/18 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|--|---|
| A | 10.06.07 | New Issue | KJ | |
| B | 10.08.09 | Dimensions revised per Dwg Rev B | KJ  |  |

| W/O: | | WORK ORDER CHANGES | | | | | |
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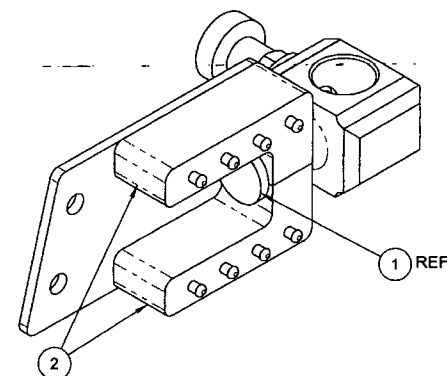
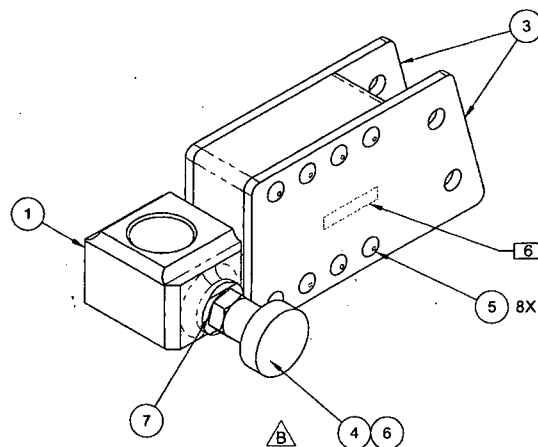
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|-----------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 1 | D3912-1 | EYEBOLT |
| 2 | 2 | D3912-3 | EYEBOLT BLOCK |
| 3 | 2 | D3912-5 | EYEBOLT PLATE |
| 4 | 1 | D3801-1 | SPRING PLUNGER |
| 5 | 8 | MS20815-4M20 | RIVET |
| 6 | 1 | MS21209-F615 | HELICAL |
| 7 | 1 | NAS1149F0332P | WASHER |



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65152
B/H-01-6

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 1.58 lbs

| B | D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1. | JPH | 10.06.28 |
|------------|--|-----|----------|
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>[Signature]</i> | | |
| DRAWN | <i>[Signature]</i> | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | | |
| DATE | 10.06.28 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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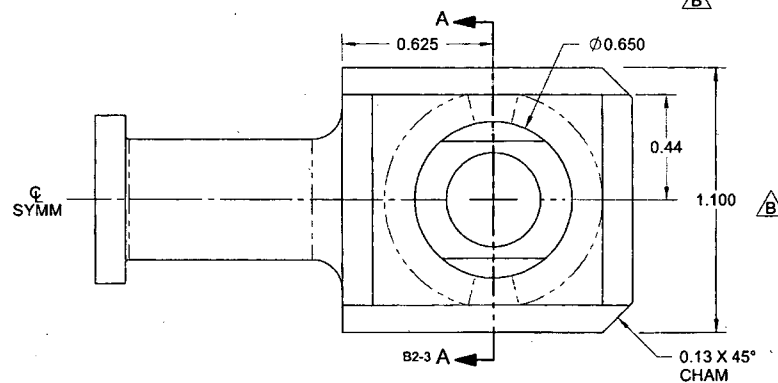
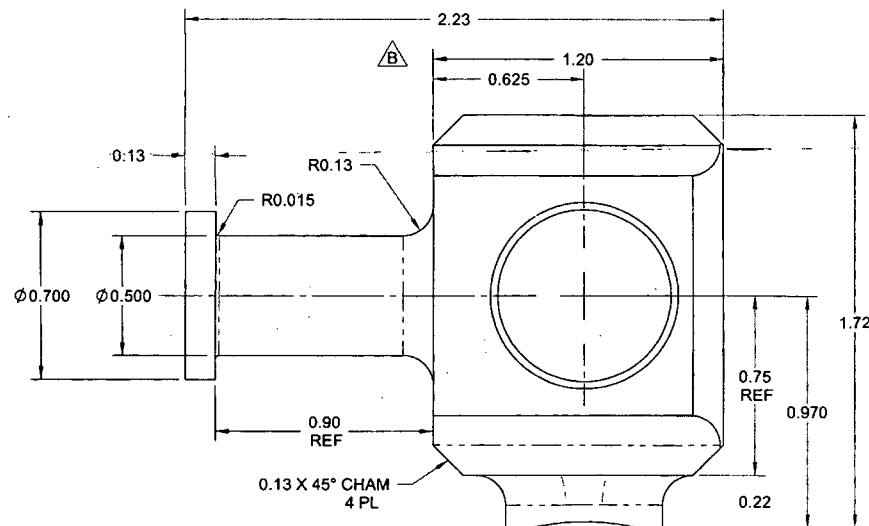
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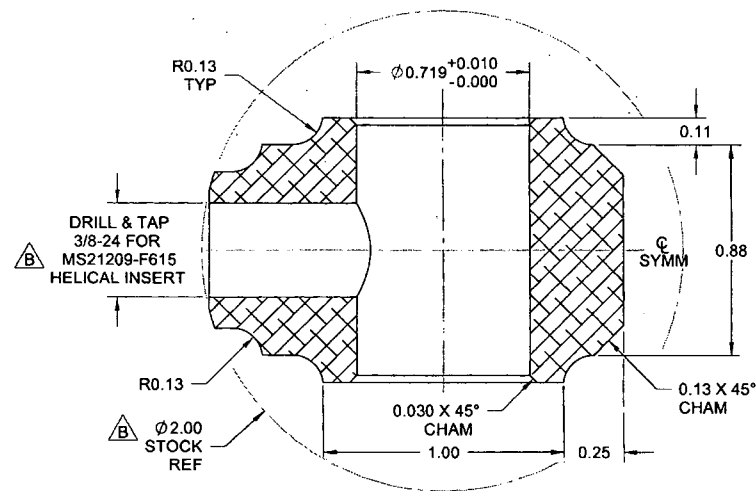
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JS | DRAWING NO. | REV. B |
| CHECKED | JS | D3912 | SHEET 2 OF 3 |
| MFG. APPR. | JS | TITLE | SCALE |
| APPROVED | JS | EYEBOLT RECEIVER ASSY | NTS |
| DE APPR. | JS | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 10.06.28 | | |

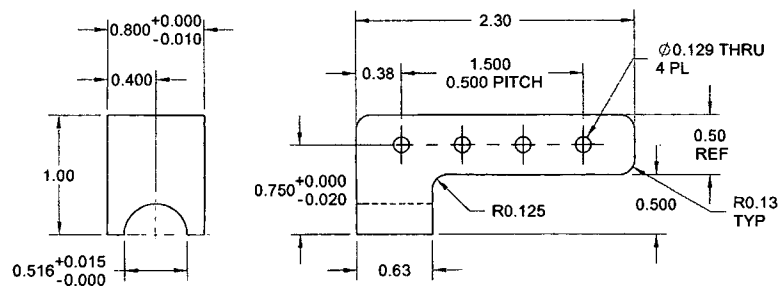
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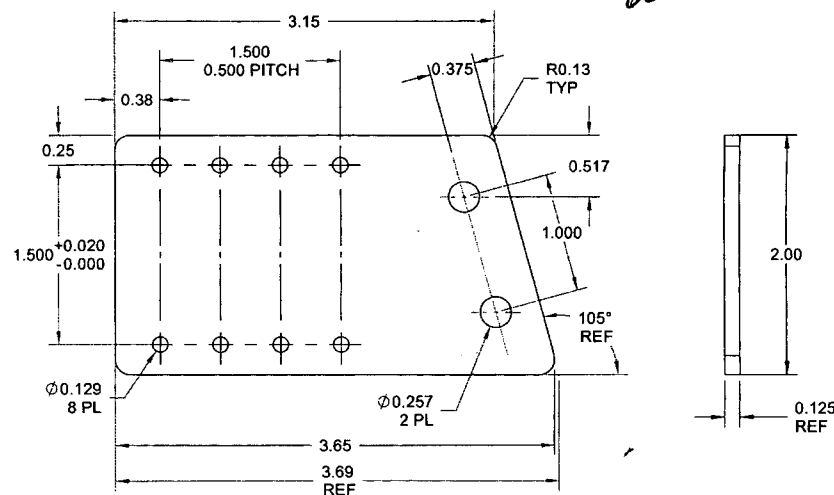
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NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs

-5: 0.24 lbs

RELEASED
2010-07-16
md

| | | | |
|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | BT | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | BT | DRAWING NO. | REV. B |
| MFG. APPR. | BT | D3912 | SHEET 3 OF 3 |
| APPROVED | BT | TITLE | SCALE |
| DE APPR. | BT | EYEBOLT RECEIVER ASSY | NTS |
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